Work Order ID 123986

September-04-14 11:58:21 AM

123986

Item ID: D3562-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Step Weldment

Start Date: 9/04/14 **Start Qty:** 4.00 *4*

Required Date: 9/04/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ML5 **Date:** 14-09-02 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3562 / F									
100	Large Fab	0.00				4X		0L14-10-14	
100 Large Fab									
Large Fab	**Memo** 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding	0.00							
110	QC6- Inspect dimensions to drawing	0.00				3		OCT 14 2014	DAS 24
110 QC									
Quality Control	**Memo**	0.00							
120	Chemical Conversion Coat per QSI005 4.1	0.00				3x		10/16/14	
120 HandFinish									
Hand Finishing	**Memo**	0.00							

Item ID: D3562-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Step Weldment
Start Date: 9/04/14 **Start Qty:** 4.00 ~~*4*~~ 3 Split **Cust Item ID:**
Required Date: 9/04/14 **Req'd Qty:** 4.00 ~~*4*~~ **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				3	14-10-17	RD	
130									
QC	**Memo**	0.00							
Quality Control									
140		0.00				3	OCT 17 2014		DAS 24 9-89
140	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	1- Transfer drill Rivet holes as per dwg D3562.								
	2-Touch-up rivet holes with alodine as per dwg d3562								
	3-Rivet legs using Scotch-Weld as per dwg D3562.								
	****** Ensure to wipe off any exess magnobond ******								
	A/R Scotch-Weld DP460 Batch: 12914 EXP DATE: Aug 2015								

Item ID: D3562-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Step Weldment
Start Date: 9/04/14 **Start Qty:** 4.00 *4* 3 SPLIT **Cust Item ID:**
Required Date: 9/04/14 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo**	0.00				(3)	14.10-17	DAS 9 9-89	
Quality Control									
160		0.00							DAS 24 9-89
160	Large Fab					3	OCT 20 2014		
Large Fab	**Memo**	0.00							
Large Fab	1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod 128956 2-Grind end cap welds flush as per Dwg D3562								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	**Memo**	0.00				(3)	DAS 43 9-89		DAS 38 9-89 OCT 21 2014
Quality Control									

Item ID: D3562-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Step Weldment
Start Date: 9/04/14 **Start Qty:** 4.00 ~~*4*~~ 3 SPLIT **Cust Item ID:**
Required Date: 9/04/14 **Req'd Qty:** 4.00 ~~*4*~~ **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00			DAS 51 9-89	DAS 9 9-89		14/10/21	
180 QC Quality Control	**Memo**	0.00							
190	Chemical Conversion Coat per QSI005 4.1	0.00							
190 HandFinish Hand Finishing	**Memo**	0.00							
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M129808.	0.00							
200 Powdercoat Powder Coating	**Memo** START TIME: ~~8:05~~ OVEN TEMPERATURE: ~~350°~~ FINISH TIME: ~~8:55~~	0.00							

3 Φ 14-10-21 DRL

3 Φ, 14-10-22

DAS 34 9-89

Item ID: D3562-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Step Weldment
Start Date: 9/04/14 **Start Qty:** 4.00 ~~*4*~~ 3 Split **Cust Item ID:**
Required Date: 9/04/14 **Req'd Qty:** 4.00 ~~*4*~~ **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Wing Walk as per dwg QSI005 4.4 Batch 4413028								
210						x3	4	98	4/10/22
HandFinish	**Memo**	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							DAS 38 9-89
220						(3)			14-20-23
QC	**Memo**	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: G-A	0.00							DAS 36 9-89
230						3x			14/9/03
Packaging	**Memo**	0.00							
Packaging	W/O 123982								

Item ID: D3562-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Step Weldment

Start Date: 9/04/14 **Start Qty:** 4.00 *4*
Required Date: 9/04/14 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	**Memo**	0.00				_____	_____	14/11/6	
Quality Control									

14-11-06

Picklist Print

September-04-14 11:58:23 AM

Work Order ID: 123986 *123986*

Parent Item: D3562-041 *D3562-041*

Parent Item Name: Step Weldment

Start Date: 9/04/14 **Required Date:** 9/04/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments:
IPP Rev:A New Issue 06-11-09 JLM
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by:ec
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C *D2622-120C* Step Extrusion		Manufactured	No			100	Each	115.0000	1 **	4			
				Location		**Loc Qty**		**Loc Code**					
				HALL		111							
					109575	32							
					119621	79							
				WA003		4							
					101765	1							
					115141	3							
D2734 *D2734* Step End Plate		Manufactured	No			140	Each	47.0000	2 **	8			
				Location		**Loc Qty**		**Loc Code**					
				WA003		47							
					119286	35							
					119498	11							
					99709	1							
D3560-041 *D3560-041* Arm Weldment		Manufactured	No			140	Each	5.0000	1 **	4			
				Location		**Loc Qty**		**Loc Code**					
				WA003		5							
					108798	1							
					119472	4							

Work Order ID: 123986
Parent Item: D3562-041
Parent Item Name: Step Weldment

123986
D3562-041

Start Date: 9/04/14 **Required Date:** 9/04/14
Start Qty: 4.00 **Required Qty:** 4.00

D3560-043	Manufactured	No	140	Each	4.0000	1	4	CpC 14.10.16
D3560-043						**		
Arm Weldment								

Location	Loc Qty	Loc Code
WA003	4	
119367	4	

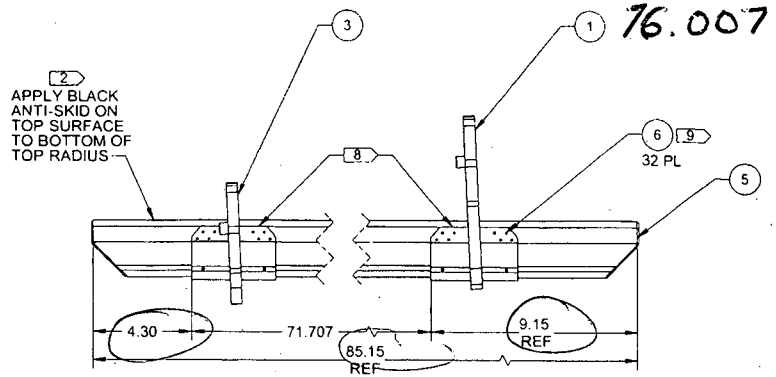
B119367 → B119367→3

MS20600-AD4W5	Purchased	No	160	Each	744.0000	32	128	PC 14.10.16
MS20600-AD4W5						**		
Blind Rivet								

Location	Loc Qty	Loc Code
ST310	372	
m129820	372	
WA003	372	
m129472	372	

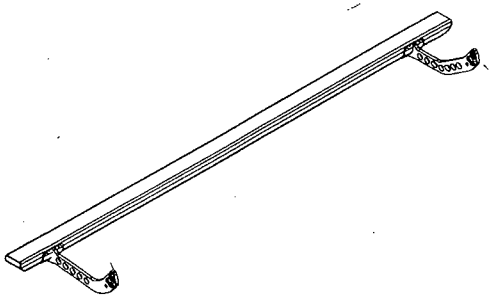
128

76.007

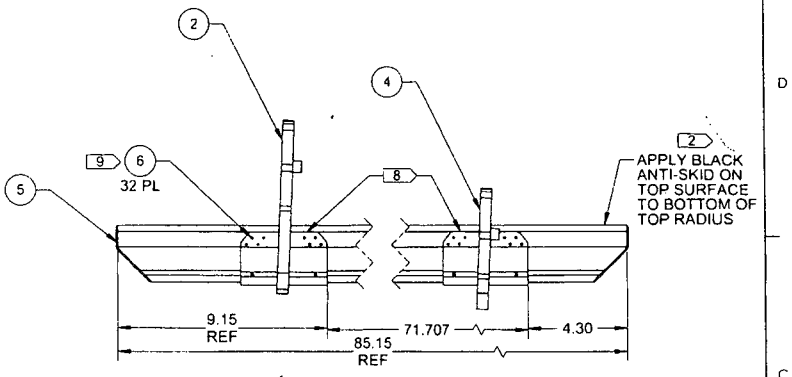


MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

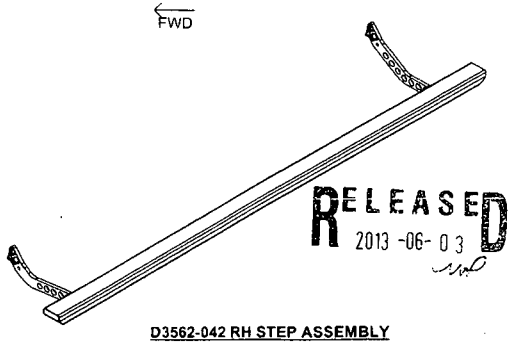


D3562-041 LH STEP ASSEMBLY



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



D3562-042 RH STEP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123986 MCJ
14-09-04

RELEASED
2013 -06- 03

NOTES:

1) MATERIAL: N/A
2) FINISH:
   i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
   GREY SANDTEX (4.3.5.6) OR
   BLACK SANDTEX (4.3.5.7) OR
   GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
   ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 8.79 lbs
8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

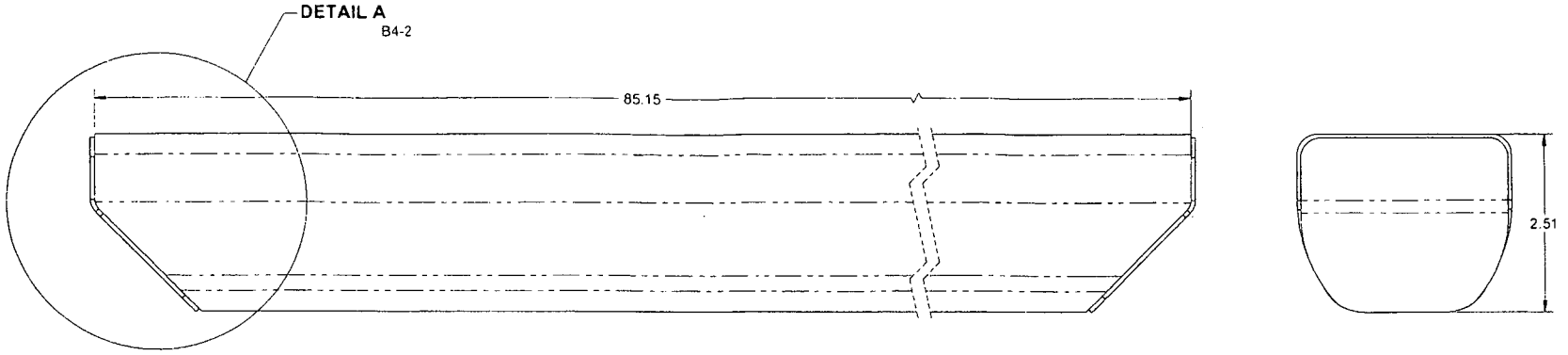
ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET

REV.	DESCRIPTION	BY	DATE
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26

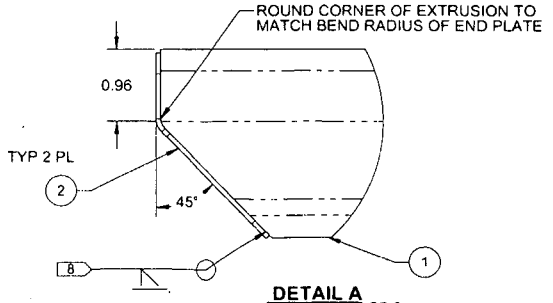
DESIGN	
DRAWN	DW
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.05.15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3562 REV. F
SHEET 1 OF 2
TITLE STEP ASSEMBLY SCALE NTS



D3562-1 STEP ASSEMBLY



DETAIL A C7-2

TYP BOTH ENDS
SCALE 1X

RELEASED
2013 -06- 03

NOTES:

1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
   PER DART QSI 005 4.1 BEFORE ASSEMBLY
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 6.68 lbs
8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
   BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM No.	QTY -1	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DW	
CHECKED	GP	DRAWING NO. D3562 REV. F
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE STEP ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.05.15	